Work Order ID 71027

Tuesday, June 21, 2011 10:15:03 AM

Item ID: D3508-13
Revision ID:
Item Name: Wearplate
Start Date: 6/21/2011 **Start Qty:** 6.00
Required Date: 6/27/2011 **Req'd Qty:** 6.00
Reference:

Accept

Setup Start
Stop

Cust Item ID:
Customer:

Approvals: **Process Plan:** P **Date:** 11-06-21 **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**									
D3508 / Rev C									
100	FLOW WATER JET	0.00							
Waterjet	**Memo**	0.00				B11-6-30			
FLOW CNC Waterjet	1-Cut as per Dwg D3508 ☐Dwg Rev: C ☐Prog Rev: C ☐2- Deburr if necessary								
304.dwg								(12)	
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00				B11-6-36			
Quality Control									
120	QC8- Inspect parts - second check	0.00							
QC	**Memo**	0.00				(12)			
Quality Control									

Sw 07/04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 71027

Tuesday, June 21, 2011 10:15:03 AM

Item ID: D3508-13 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Wearplate

Start Date: 6/21/2011 **Start Qty:** 6.00 **Cust Item ID:**

Required Date: 6/27/2011 **Req'd Qty:** 6.00 **Customer:**

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Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
Brake NC	NC BRAKE					12			
	Memo	0.00							
Brake NC	1-Form on brake using DT8326 and DT8261as per Dwg D3508		SB 11/07/05						
140	QC5- Inspect part completeness to step on W/O	0.00							
QC			8 11/07/05			12			
	Memo	0.00							
Quality Control									
150		0.00							
Large Fab	Large Fab					12 11-7-18			
	Memo	0.00							
Large Fab	Weld hardcoat as per dwg D3508 QSI004□Hardcoat 2059b Batch: M119196								

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Work Order ID 71027

Tuesday, June 21, 2011 10:15:03 AM

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Revision ID:

Item Name: Wearplate

Start Date: 6/21/2011 **Start Qty:** 6.00 **Cust Item ID:**

Required Date: 6/27/2011 **Req'd Qty:** 6.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC10- Inspect visual per QSI004- ground welds	0.00							
QC	Memo	0.00 Sulcs/ce							
Quality Control									
170	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00 Sulcs/ce				12			
Quality Control									
180	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
Powdercoat	M117338 Memo	0.00				12		BK 11-7-18.	
Powder Coating	START TIME: 1:00 ☐OVEN TEMPERATURE: 320° ☐FINISH TIME: 1:30.								

Dart Aerospace Ltd

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Work Order ID 71027

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC3- Inspect Part Finish	0.00				12	4		11/07/18
QC	Memo	0.00							
Quality Control									
200	Identify as per dwg & Stock Location: FP-16	0.00				12	0		11/07/18
Packaging	Memo	0.00							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00						11/7/19	
QC	Memo	0.00							
Quality Control									

11-07-18 (12)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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Picklist Print

Tuesday, June 21, 2011 10:15:10 AM

Work Order ID: 71027

Parent Item: D3508-13

Parent Item Name: Wearplate

Start Date: 6/21/2011 **Required Date:** 6/27/2011

Start Qty: 6.00 **Required Qty:** 6.00

Comments: IPP Rev:A New Issue 07.06.12 EC
IPP Rev:B Rev C dwg 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 304/316 .040 Sheet		Purchased	No			100	sf	236.6630	0.172	1.086316	2.		

IB11-6-30

Location	Loc Qty	Loc Code
MAT020	236.663	
116623	0.2	
117550	9.363	
117933	227.1	

117933

12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

DART AEROSPACE LTD	Work Order:	71027
Description: Wearplate	Part Number:	D3508-13
Inspection Dwg: D3508 **Rev:** C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
8.38	+/-0.030	8.386	✓		PROW302	
5.625	+/-0.010	5.628	✓		V BC2	
0.375	+/-0.010	.373	✓		V	
2.813	+/-0.010	2.809	✓		V	
2.063	+/-0.010	2.068	✓		V	
Ø0.187	+0.005/-0.001	.190	✓		V	
0.300	+/-0.010	.303	✓		V	
0.300	+/-0.010	.302	✓		V	

Measured by:	RB	Audited by:	S	Prototype Approval:	N/A
Date:	11-6-30	Date:	11/07/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.23	New Issue	KJ/EC/DD	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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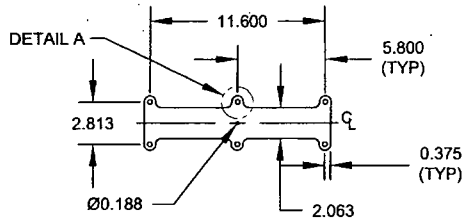
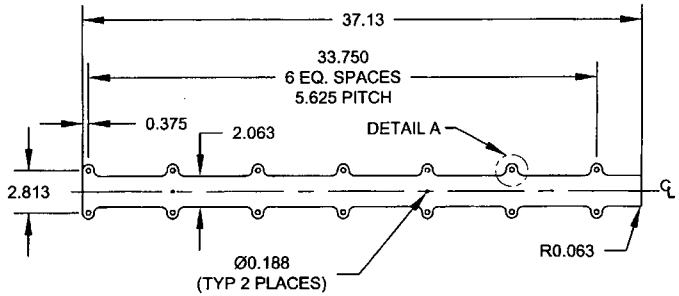
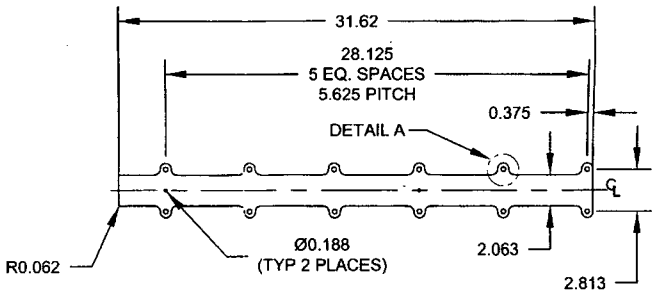


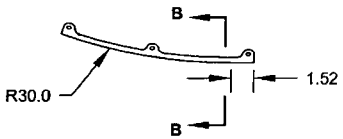
D3508-1 FLAT PATTERN



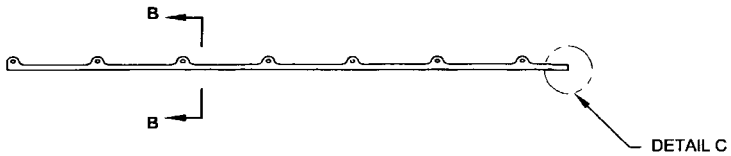
D3508-3 FLAT PATTERN



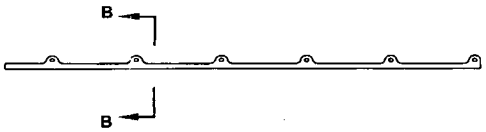
D3508-5 FLAT PATTERN



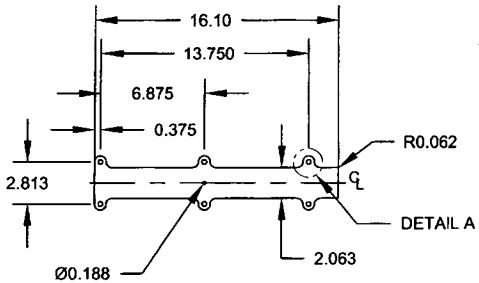
D3508-1 BENDING DETAIL
(MAKE FROM D3508-1F)



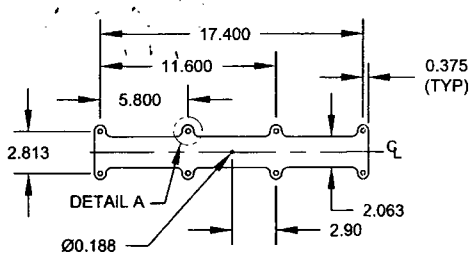
D3508-3 BENDING DETAIL
(MAKE FROM D3508-3F)



D3508-5 BENDING DETAIL
(MAKE FROM D3508-5F)



D3508-7F FLAT PATTERN

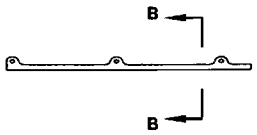


D3508-9F FLAT PATTERN

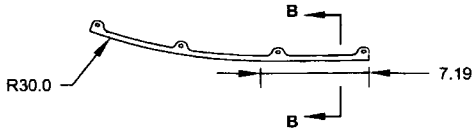
NOTES:

1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF. DART MATERIAL SPEC M304S20GA)
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
3) WELD PER DART QSI 004
4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005 TO 0.015
7) IDENTIFICATION: NONE
8) WEIGHT: D3508-1 - 0.47 lbs, D3508-3 - 0.95 lbs, D3508-5 - 0.77 lbs, D3508-7 - 0.39 lbs, D3508-9 - 0.45 lbs, D3508-11 - 0.64 lbs D3508-13 - 0.25 lbs

RELEASED 07.11.16



D3508-7F BENDING DETAIL
(MAKE FROM D3508-7F)



D3508-9F BENDING DETAIL
(MAKE FROM D3508-9F)

REV.	DESCRIPTION	BY	DATE
C	ADD -9/-11/-13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT	PH	07.04.20
B	CHANGE STAINLESS STEEL, WIDEN	PH	06.10.27
A	NEW ISSUE	PH	06.04.21

DESIGN		**DART AEROSPACE USA, INC** PORT HADLOCK, WA
DRAWN		DRAWING NO. D3508 — REV. C — SHEET 1 OF 2
CHECKED		TITLE: WEARPLATE — SCALE 1:8
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	07.04.20	

2011-06-21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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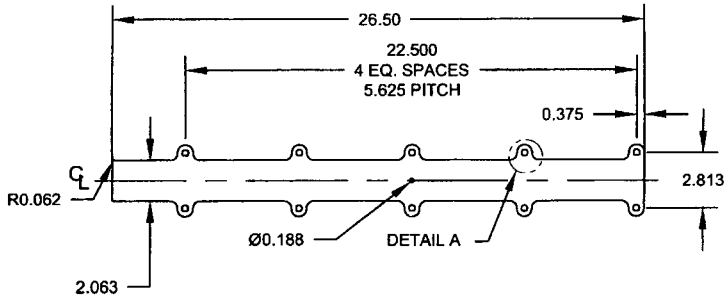
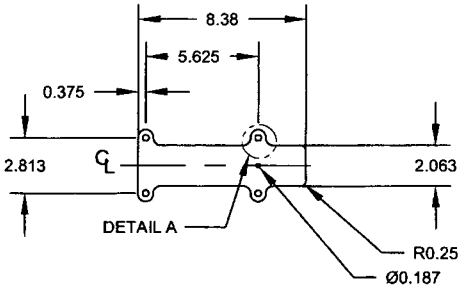
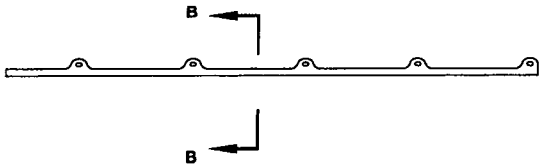
H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE



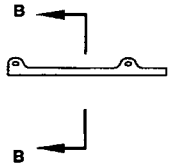
D3508-11F FLAT PATTERN



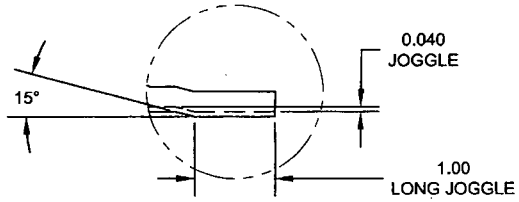
D3508-13F FLAT PATTERN



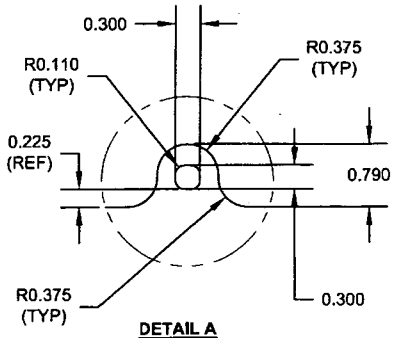
D3508-11 BENDING DETAIL
(MAKE FROM D3508-11F)



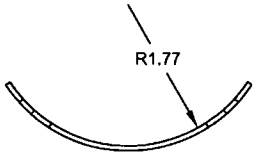
D3508-13 BENDING DETAIL
(MAKE FROM D3508-13F)



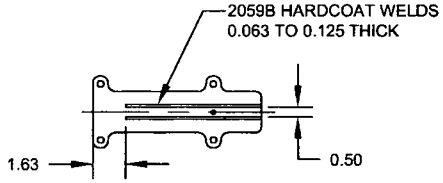
DETAIL C
(SCALE 1:2)



DETAIL A
(SCALE 2:3)



SECTION B-B
(SCALE 2:3)



D3508-13 WELDING DETAIL

w/o 71027

RELEASED 07-11-16

DESIGN	PH	**DART AEROSPACE USA, INC** PORT HADLOCK, WA	
DRAWN	PH		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3508	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	1:6
DATE	07.04.20		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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